

# Work Order ID 79100

\*79100\*

Page 1

January-19-12 3:18:04 PM

Item ID: D3204-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Release Pedal Assembly  
 Start Date: 19/01/2012 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 02/02/2012 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3204	Rev A1

100	Large Fab	0.00							
*100*									
Large Fab	Memo	0.00							
Large Fab	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.								

EL 12-3-28 (X6)  
Pto

110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

6 Ø BE 12-03-29

W/O:		79100 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3204-04 PAR #: \_\_\_\_\_ Fault Category: Large Part / welding NCR: Yes No DQA: John Date: 12/04/04  
12-1300 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 12/4/4

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 275.56						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/04	# 100	Qty x1 has the hole in D3204-3 0.375" measure 0.350 x 0.320. elongated. ie		SCRAP. NO REPLACE	<u>CL</u> 12-3-29	<u>S</u> 12/03/29		<u>S</u> 12/03/04
12/03/29	# 100	<u>Q</u> L.C welder was flattening out Parts when Arm was hot. LOA.	<u>12/03/29</u> <u>Q51042</u>					<u>S</u> 12/03/29
			<u>12/04/04</u> <u>Q51042</u>				<u>12/04/04</u> <u>Q51042</u>	

NOTE: Date & initial all entries

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January-19-12 3:18:04 PM

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 Start Date: 19/01/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 02/02/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	Sched 129			(PS)	(X)		
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	5X Ø M-L 12/03/29						
140 <b>*140*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo ***Cover holes for bushing*** START TIME: 10h10 OVEN TEMPERATURE: 326°F FINISH TIME: 10h40	0.00 0.00	m117 338			5	2	(PP)	12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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 Reference:

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
*150*						5	BL 12.3.29		
QC	Memo	0.00							
Quality Control									
160		0.00							
*160*	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Install D3204-7 bushing as shown in Dwg D3204								
170	QC5- Inspect part completeness to step on W/O	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

*[Handwritten signature]*

8 12/03/29 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
*180*									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
*190*									
QC	Memo	0.00							
Quality Control									

Q1203-29

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

January-19-12 3:18:09 PM

Page 1

Work Order ID: 79100

\*79100\*

Parent Item: D3204-041

\*D3204-041\*

Parent Item Name: Release Pedal Assembly

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3204-1		Manufactured	No			100	Each	8.0000	1	6			
*D3204-1*									**			EL 12-3-27	
Tube													

77294 X 3

Location	Loc Qty	Loc Code
WA021	8	

D3204-11		Manufactured	No			100	Each	24.0000	1	6			
*D3204-11*									**			EL 12-3-27	
Plate													

Location	Loc Qty	Loc Code
WA021	8	

Location	Loc Qty	Loc Code
WA021	24	

Location	Loc Qty	Loc Code
WA021	10	

D3204-13		Manufactured	No			100	Each	46.0000	2	12			
*D3204-13*									**			EL 12-3-27	
Gusset													

Location	Loc Qty	Loc Code
WA021	46	

Location	Loc Qty	Loc Code
WA021	3	

D3204-3		Manufactured	No			100	Each	9.0000	1	6			
*D3204-3*									**			EL 12-3-27	
Arm													

Location	Loc Qty	Loc Code
WA021	9	

Location	Loc Qty	Loc Code
WA021	1	

779801 X 2

Location	Loc Qty	Loc Code
WA021	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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January-19-12 3:18:09 PM

Page 2

Work Order ID: 79100

\*79100\*

Parent Item: D3204-041

\*D3204-041\*

Parent Item Name: Release Pedal Assembly

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 6.00

Required Qty: 6.00

D3204-5 Manufactured No

100 Each 8.0000 1 6

\*D3204-5\*

Arm

\*\*

EL 12-3-27

79292 x 3

Location

Loc Qty

Loc Code

WA021

8

71608

8

3

D3204-9 Manufactured No

100 Each 11.0000 1 6

\*D3204-9\*

Pedal

\*\*

EL 12-3-27

Location

Loc Qty

Loc Code

WA

6

77592

6

6

WA021

5

68573

5

D3204-7 Manufactured No

160 Each 17.0000 2 12

\*D3204-7\*

Bushing

\*\*

EL 12/03/29

Location

Loc Qty

Loc Code

GA

17

70323

9

77091

8

6

B 77802

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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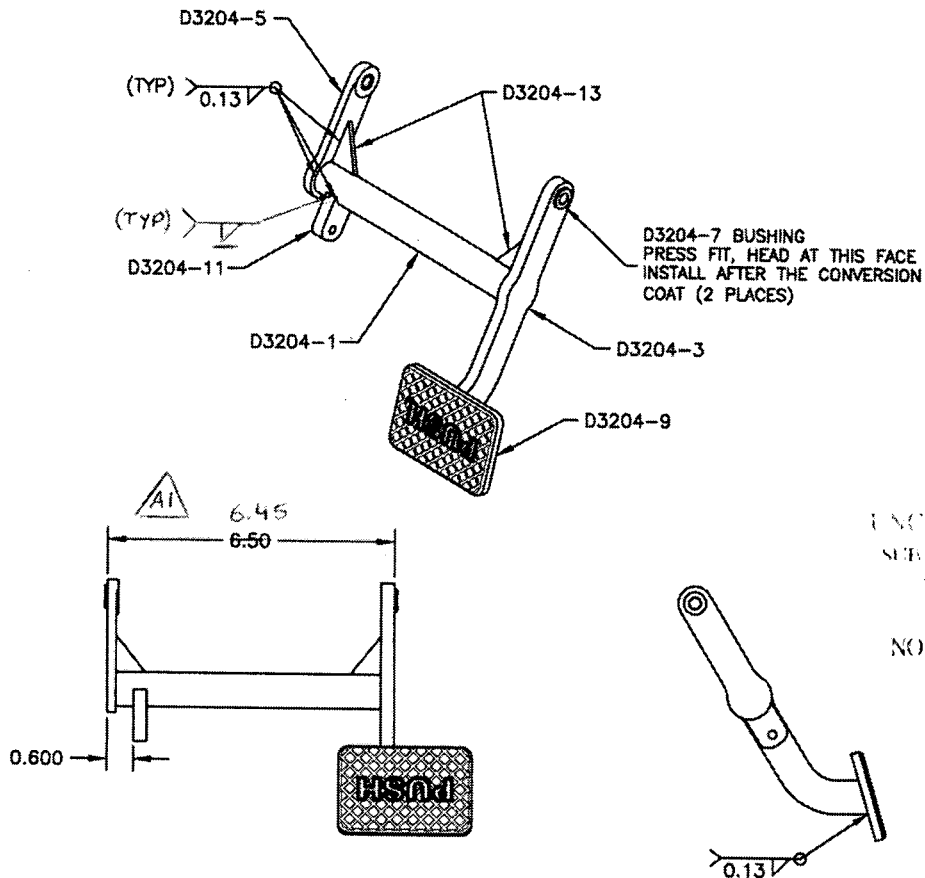
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
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AI	05.07.15	6.45 WAS 6.50	

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WELDING  
WORK ORDER  
NO. 79100 M.C.J.

12/01/19

### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

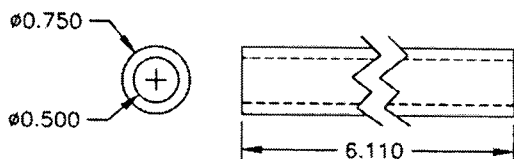
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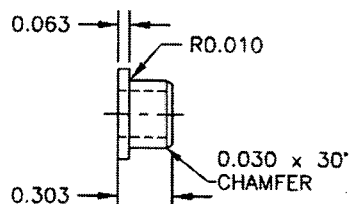


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

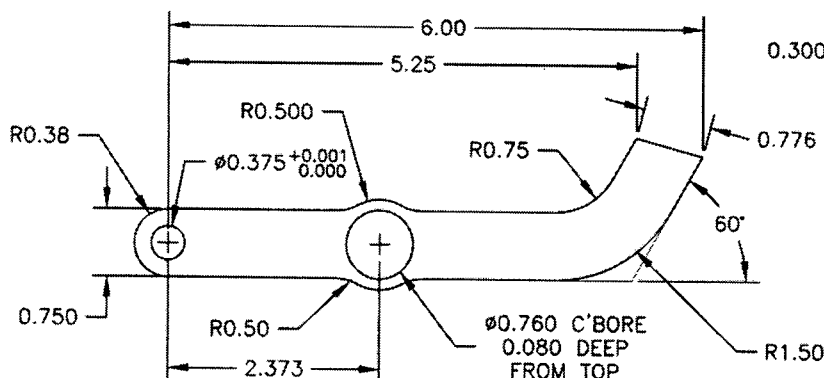
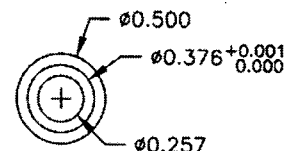
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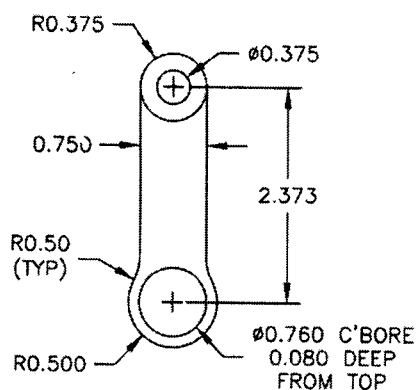
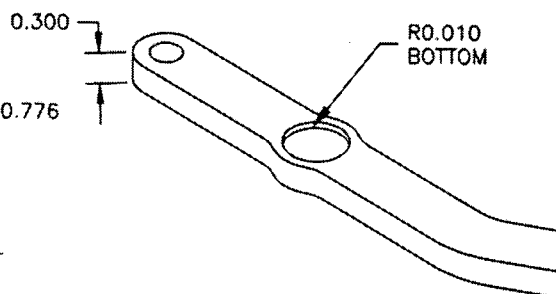
2 D3204-1 TUBE  
SCALE 1:2



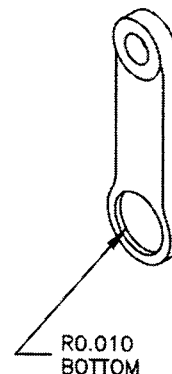
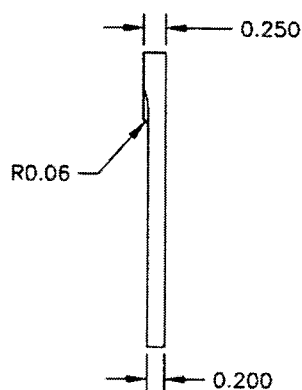
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SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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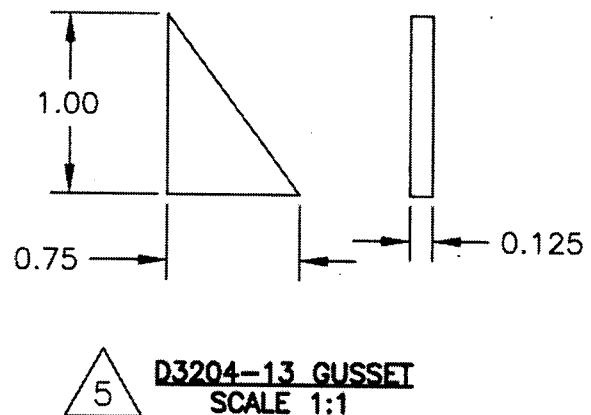
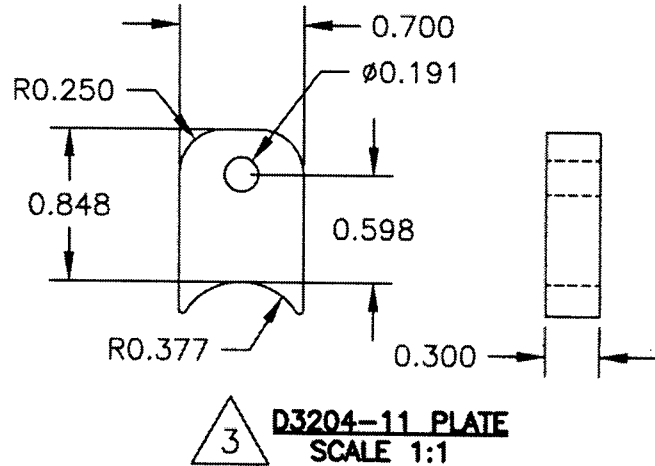
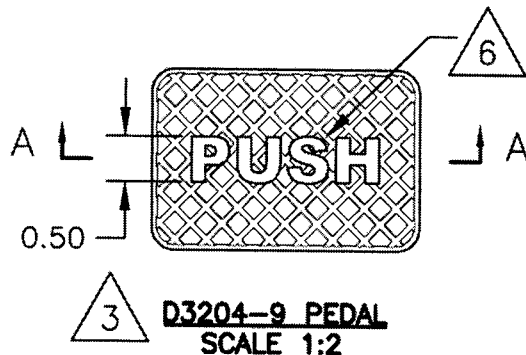
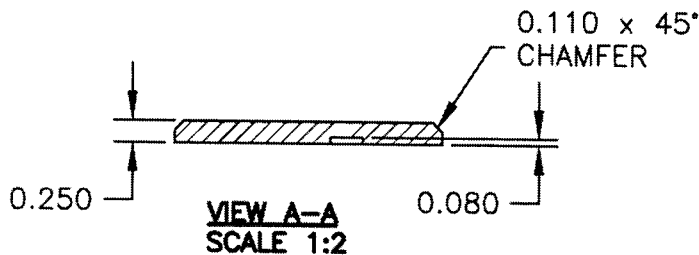
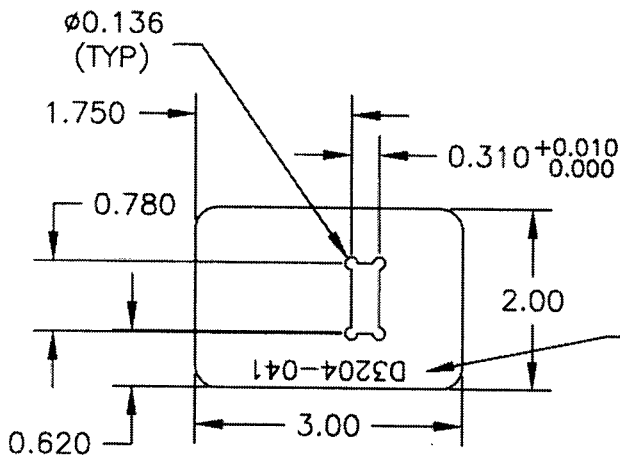




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